

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019787**Date Inspected:** 16-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Guo Tam Fei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path

PCMK: BK004A7-029

Weld No: 034~042

Welders: 056364, 044571, 040268

WPS-B-P-2312-TC-P4

Component; Bike Path

PCMK: BK004A-031

Weld No: fit-up

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Welder: 057239

WPS-B-P-2113

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Deng Zhi Bing.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path

PCMK: BK004A5-032

Weld No: 008

Welder: 056200

Weld Repair No. B-WR19147

WPS-345-SMAW-1G(1F)-Repair

Heat straightening of PCMK, BK004A1-030 under approved Heat Straightening procedure, HSR1(B)-9865. The in process temperature was observed as 230°C. The ZPMC QC was identified as Deng Zhi Bing. The approved HSR procedure stated that a maximum temperature of 600°C with 1~3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 20mm.

Bay 11

This QA Inspector observed the following work in progress for Bay 11.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wang Chuang Xin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path

PCMK: BK004A8-034

Weld No: 001

Welder: 041271

Weld Repair No. B-WR19165

WPS-345-SMAW-1G(1F)-Repair

Component; Bike Path

PCMK: BK004A8-034

Weld No: 002

Welder: 041271

Weld Repair No. B-WR19166

WPS-345-SMAW-1G(1F)-Repair

Component; Bike Path

PCMK: BK004A8-034

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Weld No: 003
Welder: 041271
Weld Repair No. B-WR19167
WPS-345-SMAW-1G(1F)-Repair

Component; Bike Path
PCMK: BK004A8-034
Weld No: 022
Welder: 041271
Weld Repair No. B-WR19168
WPS-345-SMAW-1G(1F)-Repair

Component; Bike Path
PCMK: BK004A8-022
Weld No: 022,023,024,027
Welder: 044541
WPS-B-P-2211-TC-U4b

This QA Inspector observed the following work in progress for Bay 11.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Wang Chuang Xin.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path
PCMK: BK004A1-056
Weld No: 030~033
Welder: 054460
WPS-B-T-2132-ESAB

Component; Bike Path
PCMK: BK004A8-023
Weld No: 002~007
Welder: 042218
WPS-B-T-2232-ESAB

Trial Assembly
This QA Inspector observed the following work in progress for Trial Assembly.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as An Qing Xiang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA Inspector.

Component; 12AE to 12BE

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PCMK: SP3013-001
Weld No: 013~024
Welder: 052763
WPS-B-T-2132-ESAB

Component; 12AE to 12BE
PCMK: SP3015-001
Weld No: 013~024
Welder: 044473
WPS-B-T-2132-ESAB

Component; 12AE to 12BE
PCMK: SP3016-001
Weld No: 043~052
Welder: 052763
WPS-B-T-2132-ESAB

Component; 12AW to 12BW
PCMK: OBW12D
Weld No: 002
Welder: 053486
WPS-B-T-2233-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
